

Shp Jan 30

# Work Order ID 64510



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Tuesday, December 07, 2010 9:08:02 AM

Item ID:	D2282-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	T Assembly					
Start Date:	12/7/2010	Start Qty:	150.00	Cust Item ID:		
Required Date:	1/21/2011	Req'd Qty:	150.00	Customer:		
Reference:						

Approvals:	Process Plan:		Date:	12/12/10	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D2282	Rev E								

100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	I-Weld as per D2282-041 'T' Handle Assembly Grind chamfers and ensure full penetration as per dwg D2282 *****brush weld right after welding, to take color off ***** A/RER316L SS Filling Rod <u>107051</u>								

PC 11.01.03 (93)

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									

KE 11.01.05 93 0 BER/p/05

120		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Tumble								

BU-1-11 (93)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 64510

Tuesday, December 07, 2010 9:08:02 AM



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Item ID: D2282-041

Accept



Setup Start



Revision ID:

Stop



Item Name: T Assembly

Start Date: 12/7/2010 Start Qty: 150.00



Cust Item ID:

Required Date: 1/21/2011 Req'd Qty: 150.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*Sulochi*

*count*  
*(x53)*  
*QSP019*

140

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

*Sylve*

*11/11/12*

*(93x)*

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/01/12*

*UMP*

*11-01-11*

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, December 07, 2010 9:08:05 AM

Page 1

Work Order ID: 64510

Parent Item: D2282-041

Parent Item Name: T Assembly



Start Date: 12/7/2010

Required Date: 1/21/2011

Start Qty: 150.00

Required Qty: 150.00

Comments: IPP Rev:A Removed from 9 Digit 05-12-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2282-3		Manufactured	No			100	Each	49.0000	1	150			
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Tube

Location	Loc Qty	Loc Code
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WA	49	
60279	49	

D2282-5		Manufactured	No			100	Each	39.0000	1	150			
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Tube

Location	Loc Qty	Loc Code
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ST261	39	
63070	39	

Cpl 11-01-03

B64505 → (45)

(48)

Cpl 11-01-03

B64506 → (93)

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

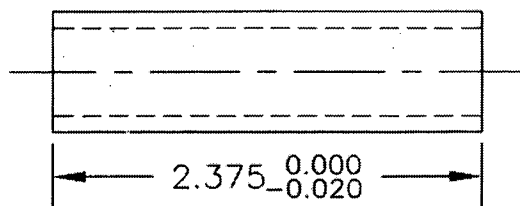
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RETURN TO  
ENGINEERING  
UNCONTROLLED (0)  
SUB

**DART**

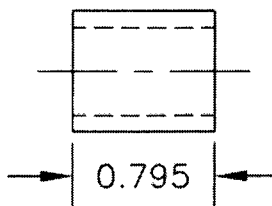
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B/10-12-7

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BS/09/16

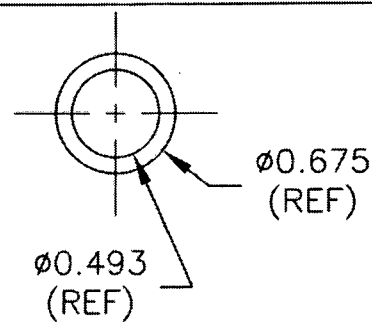
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	



**D2282-3**

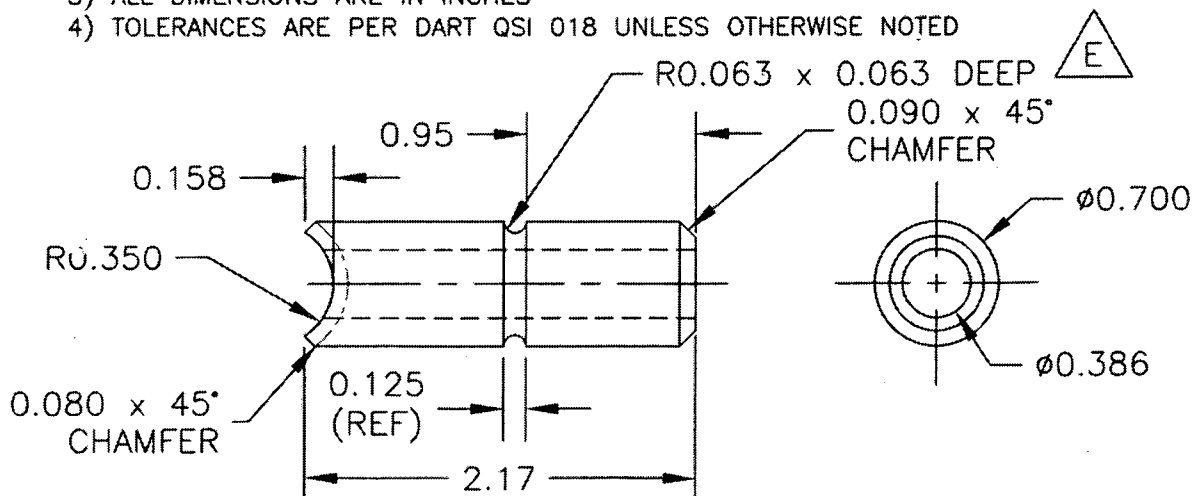


**D2282-7**



**D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



**D2282-5**

**D2282-5 STEM:**

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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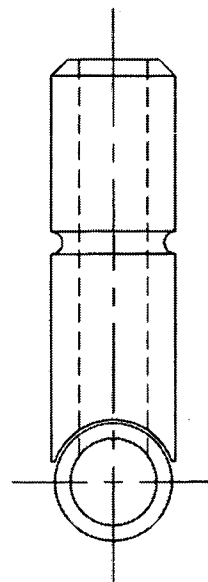
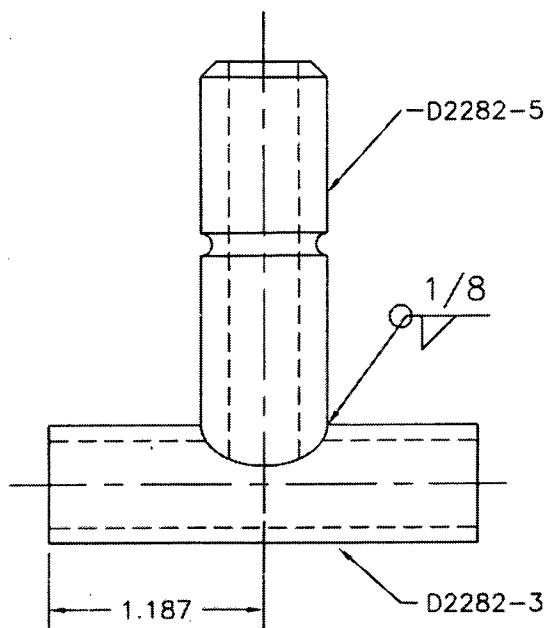
**NOTE:** Date & initial all entries



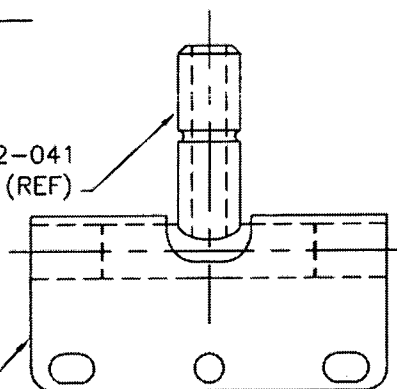


*w/044510*

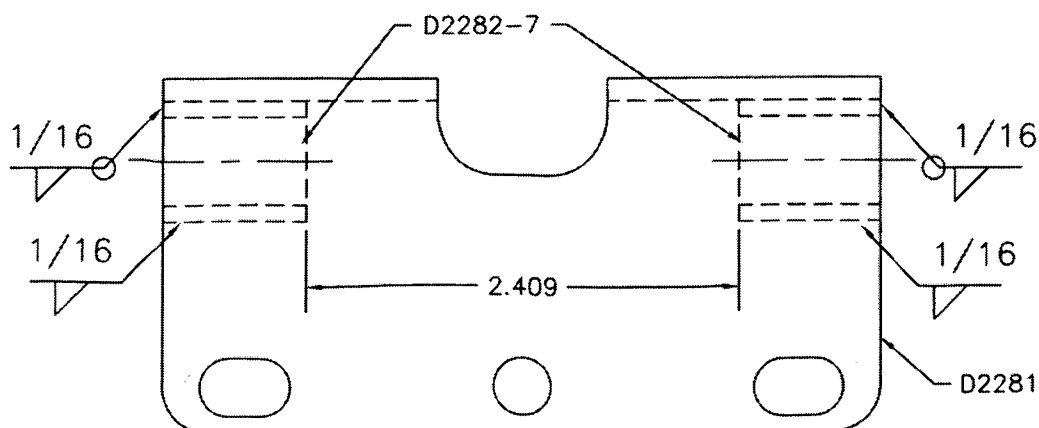
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CHECKED <i>up</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1



D2282-041  
(REF)



**GENERAL ASSEMBLY**  
SCALE 1:2



**D2282-043 SADDLE ASSEMBLY**  
WELD ASSEMBLY PER DART QSI 004

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries